Work Ord Thursday, Septe			PM _											Page 1
Item ID: Revision ID:	D4000-11					Accept					Setup	Start		
Item Name: Start Date: Required Date Reference:	Cap 9/30/2010 : 10/8/2010	Start Qty Req'd Qty					Cust Ite Custom					Stop		
Approvals:	Process Pla	an:	K	_ Date://	19-30	Tooling: SPC (Y/N):		Date:			Run	Start Stop		
Sequence ID/ Work Center I	D	Operation Description				Set Up/ Run Hours	Tool I	D Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
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D4000	A													Pbs-
Waterjet FLOW CNC Water	-	; 1	Memo 1-Cut as p Dwg Rev: Prog Rev:	H		0.00	1 1 .			B	(0-1	0-6		)
110 QC Quality Control	•	ه کدی	1	ection	n,	0.00	111/06		C	<u> </u>	. <u>(0~1</u>	<b>U-</b> డ	·	

2455	WORK ORDER CHANGES	3			,	
CTED	DDOCEDURE CHANCE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
#00	ADD correct Details. For steps \$110 (aco) and step #100 (aco)	M	10.10.13			noliolog
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	STEP	STEP Perm. Jane PROCEDURE CHANGE  ADD correct Details. For steps \$110 (aco) and	STEP Perm. Jane PROCEDURE CHANGE By	STEP Perm. PROCEDURE CHANGE  By Date	STEP Perm. PROCEDURE CHANGE  By Date Qty	STEP Perm. PROCEDURE CHANGE  By Date Qty Approval Chief Eng / Prod Mgr

Part No: <u>D4000-11</u> PAR #:	Fault Category:	_ NCR: Yes No DQA:	Date:
Resolution:	Disposition:	_ QA: N/C Closed:	_ Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	A					
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
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Page 2

Item ID:

**Revision ID:** 

Thursday, September 30, 2010 12:41:53 PM D4000-11

Item Name: Cap

**Start Date:** 9/30/2010

Start Qty: 4.00 **Required Date: 10/8/2010** 

Req'd Oty: 4.00



Accept

Date:

Date:

Run

Setup Start

Stop

Start

Stop



Reference:

Approvals:

Process Plan: \_\_\_\_

Operation

Date:\_\_\_\_\_

Date:\_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Tool ID

**Cust Item ID:** 

**Customer:** 

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

120

OC

Sequence ID/

**Work Center ID** 

Quality Control

Description

OCE enspection
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Set Up/ Run Hours

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170

Packaging Packaging

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: 09

Memo

0.00

0.00

WF 10-12

W/O:			WO	RK ORDER CHANG	GES				· ·
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	_
	R	esolution:	Disposition	):	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
				17.00					

### **Picklist Print**

Thursday, September 30, 2010 12:41:57 PM

Work Order ID: 62455

Parent Item: D4000-11

Parent Item Name: Cap



**Start Date:** 9/30/2010

Required Date: 10/8/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 10.02.03 new issue Prelim EC verified by:DD IPP rev B

10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	58.0200	0.001	0.004	1,		
										,	B10-10	5-6	

6061-T6 Sheet 0.032"

<b>Location</b>	Loc Oty	Loc Code		$\sim$
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-18375	5.9			

W/O:			WC	ORK ORDER CHANGI	ES				•
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NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC	ļ —	Corrective Action Section			cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order: 62455
DAILI ALIOO ACLES	
Description: CAP	Part Number: D 4000-11
Days A	Page 1 of 1
Inspection Dwg: 04000-1 Rev: A	

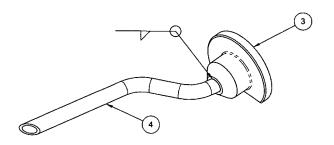
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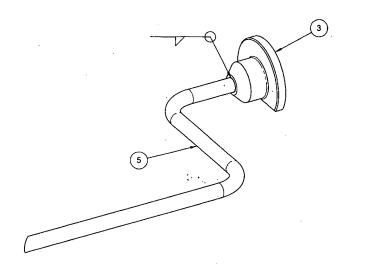
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Weasu	ned by.	图		Date:	N/A
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Rev	Date_	Change		KJ/JLM	
Α		New Issue		TO/OLIN	

	8		7	. 6	5
ITEM	QTY. -043	QTY. -045	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	х		D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
		х	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
3	1	1	D4000-3	FUEL SUMP DRAIN FITTING	
4	1		D4003-1	INTERNAL DRAIN LINE, AFT	
5	L	1	D4003-3	INTERNAL DRAIN LINE, FWD	

UNCONTROLLED COPY2 SUBJECT TO AMENDMENT WITHOUT NOTICE



D4000-041 DRAIN FITTING ASSEMBLY, AFT



**D4000-043 DRAIN FITTING ASSEMBLY, FWD** 



Α	NEW ISSU	E	,	1	10.02.10		
REV.			DESCRIPTION	BY	DATE		
DESIGI DRAWI			7	ROSPACE L' Y, ONTARIO, CANAI			
CHECKED			DRAWING NO.		REV. A		
MFG. A	PPR.	13	D4000		SHEET 1 OF		
APPRO	VED	140,	TITLE		SCALE		
DE APPR.			FITTING		NTS		
DATE	10.02	.10	THE STATE OF THE S				

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NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-043/-045" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D4000-043 - 0.04 lbs
D4000-045 - 0.05 lbs

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W/O:			WC	ORK ORDER CHANG	ES			•			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approvaí QC Inspector			
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NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR)						
DATE	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approval			
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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8 4 ITEM NO. JOHN CAMERON AVIATION PART NUMBER PART NUMBER DESCRIPTION ٠ 1 Х D4000-045 FUEL PICK UP FITTING ASSEMBLY JCA-M47-1-10 2 1 D4000-7 FUEL PICK UP FITTING 3 D4000-11 CAP 1 D4003-5 FUEL PICK UP LINE D SCALE 4X B2-2 С -B <sub>C2-2</sub> **D4000-045 FUEL PICKUP FITTING ASSEMBLY** 

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-045" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.27 lbs

8

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4000 MFG. APPR. SHEET 2 OF 8 APPROVED TITLE SCALE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTO

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:					
	Res	olution:	Disposition	n:	_ QA: N/C C	losed:		Date: _				
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	₹)						
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descript		Section B tion Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector			
		Coolema	Chief Eng	Chief Eng	Date			07.107 <b>2</b> 11g	Qo mopostor			
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3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-1 JCA-M47-1-04 D D - 0.75 -Ø 1.97 0.28 R0.02 DRILL Ø0.921 THRU-С 3/4 NPT TAP FROM-THIS SIDE Ø1.57 **SECTION C-C D4000-1 FUEL SUPPLY FITTING** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6R DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REF DART SPEC M6061T6R
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: (NCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.12 lbs REV. A D4000 MFG. APPR. SHEET 3 OF 8 APPROVED TITLE DE APPR. FITTING NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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Part No	):	PAR #:	Fault Categ	jory:	NCR:	Yes N	A: Date:			
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-3 JCA-M47-1-05

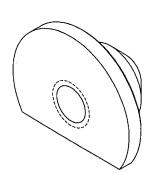
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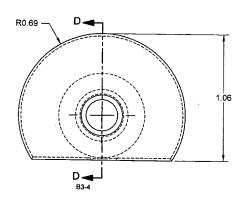
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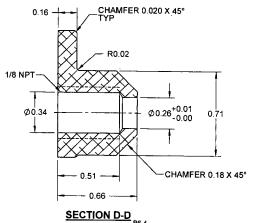
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#### **D4000-3 FUEL SUMP DRAIN FITTING**

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS4160) REF DART SPEC M6061T6R

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

DESIGN DRAWN	45	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	B	DRAWING NO.	REV. A				
MFG. APPR.	E	D4000	SHEET 4 OF 8				
APPROVED	10	TITLE	· SCALE				
DE APPR.		FITTING	NTS				
DATE 10.0	2.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PREVITAIND CONFEDENTAL WHO IS SUPPLIED ON THE EXPRESS CONSTRON THAT  NOT TO BE USED FOR MAY PURPOSE OR CORPEC OR COMMUNICATED ON MY ORBIT PERSON WITH  WASTED PERMISSION FROM DATA ARROSPACE (TO					

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W/O:			wo	RK ORDER CHANG	ES				e ig
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Res	solution:	Disposition	i:	_ QA: N/C (	Closed:		Date: _	
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DATE		Description of NC Section A			on B	Verif	ication	Approval	Approval
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign Dat	&   Sec	tion C	Chief Eng	QC Inspector
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6 5 3 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-5 JCA-M47-1-09 w/o 42455 D D Ø 1.57 0.59 R0.02 DRILL Ø0.578 THRU-С С 3/8 NPT TAP FROM -THIS SIDE 0.98 E----SECTION E-E B6-5 B3-5 **D4000-5 FUEL TANK VENT FITTING** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6R DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A 2) FINISH: N.7.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs D4000 MFG. APPR. SHEET 5 OF 8 TITLE APPROVED SCALE **FITTING** DE APPR. NTS DATE 10.02.10 COPYRIGHT © 2010 BY DART AEROSPACE LTD

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W/O:		WORK ORDER CHANGES											
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3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-7 REF JCA-M47-1-10 w/0 42455 D 0.217 С CHAMFER 0.04 X 45° 0.39 REF Ø1.05 R0.66 REF 1/4 NPT--Ø0.51<sup>+0.01</sup> Ø1.00 -3/4 NPT — 0.57 — <del>-</del> A3-6 **SECTION F-F D4000-7 FUEL PICK UP FITTING** NOTES: 1) MATÉRIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC M6061T6R DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DRAWING NO. CHECKED REV. A D4000 MFG. APPR. SHEET 6 OF 8 APPROVED TITLE SCALE **FITTING** DE APPR. NTS 6) IDENTIFICATION: N/A 7) WEIGHT: 0.10 lbs COPYRIGHT © 2010 BY DART AEROSPACE LTD
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HOT TO BE USED FOR AMY PURPOSE OR COMED ON COMMUNICATED TO ANY OTHER PERSON DATE 10.02.10 7 5 3 2

W/O:			WO	RK ORDER CHANGE	S				*
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	Part No: PAR #: Resolution:		Fault Categ	NCR: Yes	Date: _				
		esolution:							
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DATE	STEP	Description of NC		Corrective Action Section B		Verific	ation	Approval Chief Eng	Approval
DAIL	J.E.	Section A	Initial Chief Eng	Action Description  Chief Eng	ption Sign & Date		on C		QC Inspector
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION D4000-9 JCA-M47-1-11 D DRILL Ø0.60 THRU Ø1.02 Ø0.709 Ø0.748 0.13 x 45° CHAMFER--- 0.051 G<mark>→</mark> - 0.20 - 0.073 SECTION G-G B6-7 D4000-9 GROMMET DESIGN DART AEROSPACE LTD NOTES: 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.000 ROUND BAR REF DART SPEC M-DELRIN-R1.000 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A REF DART SPEC M-DELRIN-R1.000

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs D4000 MFG. APPR. SHEET 7 OF 8 TITLE APPROVED SCALE **FITTING** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			WC	RK ORDER CHANGES	3				, ka	
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #: Fault Category:			NCR: Yes	No <b>DQ</b>	A:	Date:	<del>- ,</del>	
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	OTED	Description of NC	Corrective Action Section B			Verification	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector	
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D D Ø0.50 0.032 REF D4000-11 CAP RELEASED 2010-05-05 NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.032 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REF DART SPEC M6061T6S.032
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NIA
7) WEIGHT: 0.00 lbs REV. A D4000 MFG. APPR. SHEET 8 OF 8 APPROVED TITLE SCALE FITTING DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS DOCUMENTS FRINKE AND COMPORTING HOS SUPPLIED ON THE COMPRESS CONCEINON THAT IT IS AND TO BE USED FOR ANY FLATORS ON COMPOUND COMMANDATION ON ANY OTHER PERSON WITHOUT WITH THE PROSPECT OF MONTH AT RESPONCE TO DATE 10.02.10

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								,		
Part No	Resolution:		Fault Cate	NCR: Yes No DQA: Date:						
	R	esolution:	Disposition	l:	_ QA: N/C	Closed: _		Date: _	<u>.</u>	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)		//	***************************************	
		EP Description of NC Section A			on B	Veri	fication	Approval	Approval	
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sigr Da	า& ∣ <sub>Se</sub>	ction C	Chief Eng	QC Inspector	
							<del></del>			